

## Abstract

A method and apparatus for molding molds having no flask wherein a match plate having a pattern is put between a pair of an upper and a lower flask having intakes for foundry sand. An upper and a lower molding space are defined by inserting an upper and a lower squeeze device into openings of the pair of the upper and the lower flask having no match plate, and the pair of the upper and the lower flask and the match plate are rotated and moved so that they become perpendicular and then the intakes of the flasks move upward. The upper and the lower molding space are then filled with the foundry sand. The foundry sand in the molding space is squeezed by the squeezing device. The pair of the flasks and the match plate are rotated so that they become horizontal. Then the match plate is removed, the flasks are matched to each other, and the molds are removed from the pair of flasks.